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		Number PL1E-TM-8A36-97458		
DPC Austria GmbH	Replaces revision:	Date of release/ Version 06/2006		

TECHNICAL DATASHEET

DUPONT – AQUA ÷ EC 3000

Bath	Aqua + EC 3000
Dispersion	Aqua + EC 3000 D12714144
Pigment paste	Aqua + EC 3000 8A36-97458

Description:

Aqua+EC 3000 Cathodic Electro Coat can be applied on conductive substrates. Due to its excellent mechanical properties, high corrosion protection and excellent throwing power it can be used as an universal system for all automotive supplier parts of bulk series of one colour. It can be used as a high build and standard coating system where film thicknesses of > 35 microns and 20 ± 3 microns are required.

Areas of use:

Automotive suppliers; agricultural machines

Material characteristics	Unit	D12714144	8A36-97458
Colour		milky, white	black
Viscosity		40 – 120 s ISO 3 mm	100 – 150 s ISO 4 mm
Density (measured using DIN 53217)	g/cm ³	1,07 ± 0,03	1,16 ± 0,05 g/ccm
Solid content	%	37 ± 1	45 ± 2
MEQ – Value	mVal	30 ± 4	32 ± 3
Mix ratio		3,3 – 4,3 : 1	
Flash point (measured using DIN 53213)	°C	> 80 °C	> 80 °C
Storage stability		max. 6 Months (+ 5°C bis + 30°C)	
Hazard category as per VbF dated 5.6.1970		Not applicable	

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Processing of material

Substrate pretreatment	Zinc phosphatation	
pH-Value	6,0 ± 0,3	
Conductivity	1500 ± 400	µScm ⁻¹
Solid content	14 – 17	%
MEQ-Value	35 – 41	mVal
Ash to binder ratio	0,20 – 025	: 1
Deposition equivalent	40 ± 5	As/g
Density of solids	1,31 ± 0,05	g/cm ³
Theoretical material requirement to achieve dry coating thickness of 20 microns	26,2	g solids
Coating time	180	s
Bath temperature	32 ± 1	° C
Deposition voltage	160 – 400 (depending on the plant conditions)	V
Coating thickness	20 ± 2; > 35	µm

Drying of product

> 18 Min. > 150 °C Object temperature

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Mechanical characteristics

Grid section DIN EN ISO 2409 Gt 0 - 1

Corrosion protection

Humidity test	DIN 50017	480 h	creep	: < 1 mm
Salt spray test	DIN 50021	504 h	creep	: < 1 mm
	DIN 50021	1008 h	creep	: < 1,5 mm
VDA - cycle test	VDA 621-415	10 cycles	creep	: < 2 mm
1 day = 24 h SST	DIN 50021			
4 days = 4 cycles KK	DIN 50017			
2 days = 48 h RT	DIN 50014			
Evaluation according to DIN EN ISO 7253				
VW - cycle test	PVW 1210	30 / 60 cycles		
Evaluation according to DIN EN ISO 7253			creep	: < 2,5 mm
Volvo Vict test	STD 1027,1375	12 cycles	creep	: < 9 mm

Evaluation of edge protection on original parts

Break oil resistance according to TEVES ATE N 550 : 24 h

Chemical resistance VDA 621- 412 :

HD - oil; petrol leadfree; cold cleaners; break fuel : O.K.

The material fulfils the following specifications:

- > **BMW:** 60087.0 ; GS90011 LASW 3
- > **DB:** DBL 7391-04; 7390-50; 7392-10; 7392-50
- > **FORD:** SM 2P 4537B, SM 2P 1015A, SLK 2P 9101, SSM-2P-9552-A, SSM 2P 9579, WSK-N2P137-A3, WSK M2P 153 A1-A6
- > **OPEL:** GME 4201, GME 0007 A1-A3, GME 00201 A/B
- > **Volvo:** STD 5751,5 Y 500-3 (außer Weather-O-Meter)
- > **VW:** TL 227; TL 260; Ofi - x- 630 ; Ofi - x 634 ; 13750 OFL x 630/634
- > **MAN:** MAN M 3018 Klasse 1-4
- > **Saab:** STD 1090
- > **Porsche:** PN 11003 T1-T3

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Issue : 06/2006

This issue cancels and replaces all previous data sheet issues.

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